

Date: Monday, 2/5/2007 11:11:58 AM  
User: Chantal Lavoie

# **Process Sheet**

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : GUIDE
<b>Job Number</b> : 30588	
<b>Estimate Number</b> : 12687	
<b>P.O. Number</b> : <i>N/A</i>	<b>Part Number</b> : D35711
<b>This Issue</b> : 2/5/2007 <b>S.O. No.</b> : <i>N/A</i>	<b>Drawing Number</b> : D3571 UNDER REVIEW <i>E</i>
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : 2/2/2007 <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : U/R
<b>Previous Run</b> :	<b>Material</b> : <i>N/A</i>
<b>Written By</b> : <i>[Signature]</i>	<b>Due Date</b> : 2/9/2007 <b>Qty:</b> 6 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <i>[Signature]</i>	
<b>Comment</b> : Est Rev:A New Issue 07-02-01 JLM	

## **Additional Product**

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0750X01500	6061-T6 Bar .75" X 1.5"
<b>Comment:</b> Qty.: 0.2531 f(s)/Unit Total: 1.5183 f(s) 6061-T6 Bar .75" X 1.5" Batch: <i>M102447 m102447</i> <i>MS 07102105</i> <i>(64)</i>		
2.0	BAND SAW	BAND SAW
<b>Comment:</b> BAND SAW Cut blank 2.90" long <i>MS 07102105</i> <i>7</i>		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
<b>Comment:</b> HAAS CNC VERTICAL MACHINING #1  1- Mill as per Folio FA675Rev: <i>AA</i> & Dwg D3571 Rev: <i>A</i>  2-Deburr per dwg D3571 <i>Ep/ MS 07102105</i> <i>(64)</i>		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE <i>Ep/ MS 07102105</i> <i>(64)</i>		
5.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
<b>Comment:</b> CONVENTIONAL MILLING MACHINE C'SINK PARTS AS PER DWG D3571 <i>Ep 07102105</i> <i>(x7)</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: RD Date: 07/03/01  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/5/2007 11:11:59 AM  
User: Chantal Lavoie

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE

Job Number: 30588

Part Number: D35711

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

En 07/02/06 (X7)

7.0

QC8

SECOND CHECK

**ENGINEERING  
APPROVAL**



Comment: SECOND CHECK

UE 07.03.21 3G 07-02-07 7

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MB/YL

(7X) 07/02/07

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

grane fook?

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: \_\_\_\_\_

FOR ENGINEERING USE ONLY

UE 07.03.21

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(7) 07/03/07

Job Completion



UE 07.03.05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

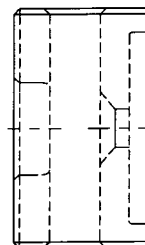
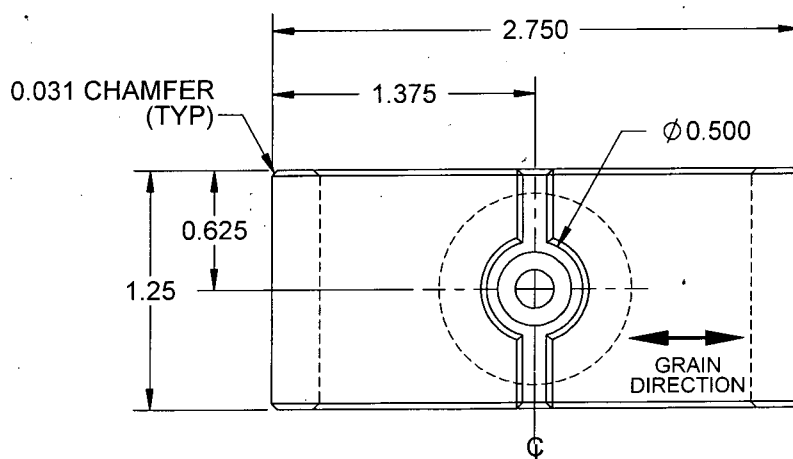
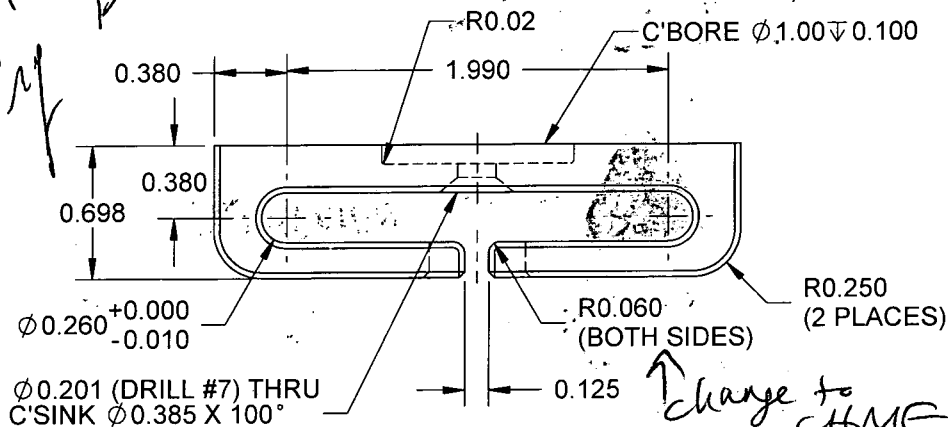
NOTE: Date & initial all entries

# PRELIMINARY ISSUE

## UNDER REVIEW

07-01-30 LE

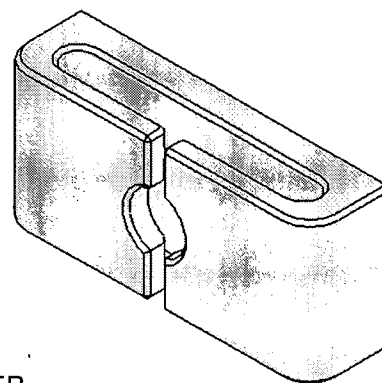
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED	DRAWING NO. D3571	REV. A SHEET 1 OF 1
DATE 07.01.29	TITLE GUIDE		
REV A	DATE 07.01.29	DESCRIPTION NEW ISSUE	



### D3571-1 GUIDE

#### NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR  
PER QQ-A-225/8 OR AMS 4117/4128/4115/4116  
OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3571-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT  $\phi$



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**INDALEX**  
ALUMINUM SOLUTIONS

REFERENCE ONLY

48411

Bundle  
Number  
13741  
13742

**MECHANICAL TESTING & CHEMICAL CERTIFICATION**

<b>Customer</b>	<b>Date</b>	<b>Location</b>	<b>Test #</b>
ASA	3/24/2006	Mississauga	27166
<b>Customer #</b>	90	<b>Order #</b>	6031952
<b>Control #</b>	51722-1	<b>P.O. #</b>	057217-RK-1
<b>Cust Part #</b>	AF61.750X1.500	<b>Die #</b>	AS 7801
<b>Alloy &amp; Temper</b>	6061 T6511	<b>Cast</b>	37398

**Sample dimensions**

<b>Width</b>	<b>Thickness</b>	<b>Area</b>
0.434	0.343	0.1489

**Test results**

<b>Hardness</b>	<b>Yield Stress (PSI)</b>	<b>Min Required</b>	<b>Actual</b>
Rockwell		35,000	38,080
Webster B	<b>Ultimate Stress (PSI)</b>	38,000	41,114
16	<b>% of Elongation in 2"</b>	8	14

**Typical Chemistry** 6061

<b>Si</b>	<b>Fe</b>	<b>Cu</b>	<b>Mn</b>	<b>Mg</b>	<b>Cr</b>	<b>Ni</b>	<b>Zn</b>	<b>Ti</b>
0.4-0.8	0.7mx	0.15-0.4	0.15mx	0.8-1.20	0.04-0.35	0.05mx	0.25 mx	0.15mx

Tensile testing is performed according to ASTM B557.84 requirements  
Mechanical test results conform to specifications for ASTM B 221/SB221, ASTM B 308/ B 308M  
except for Sec. 8.2 (Number of Specimens) which is determined by customer requirement  
The aluminum extrusions tested meet the chemical composition requirements of the alloy specified.

Test certified by MARQUEZ BAYASEN

Date 3/24/2006

Indalex Ltd.  
5675 Kennedy Rd.  
Mississauga, ON, L4Z 2H9

Tel: (905) - 890 - 8821  
Fax: (905) - 890 - 3670

Form #  
Rev. Date: A

# Receiving Report

REFERENCE ONLY

Date: 6/10/20  
Supplier: MDW

Batch No: M1-2447  
Dart P/O: 2273

Packing Slip: Yes ☒ No ☐  
Invoice: Yes ☐ No ☒  
Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐  
Waybill Attached: Yes ☐ No ☒ N/A ☐  
Shipment Complete: Yes ☒ No ☐ N/A ☐  
QC6 Inspection ☒ N/A ☒  
Work Order ☐

## Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
<del>M353R050</del>	<del>Black 15 X 158 75</del>					

Initials of receiver (if shipment OK) Level 12 [Signature]

Production/Admin:

Date: 06/10/23  
Received/Costing: RCY 2812  
Initial: LG

Location \_\_\_\_\_